

Date: Thursday, 29/03/2007 2:38:55 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 206B UTILITY BASKET

Job Number : 31543

Estimate Number : 11282

P.O. Number :

This Issue : 29/03/2007 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : LARGE FAB ASSY

Previous Run : 31455

Part Number : D206540013

Drawing Number : D206-540 REV I

Project Number : N/A

Drawing Revision : I

Material :

Due Date : 06/04/2007

As per discussion with  
 Bill B., Tech. Support/ENG.

Should follow up with  
 customer.

07-03-27  
 Qty: 1 Um: Each

Written By :

Checked &amp; Approved By :

Comment :

Est Rev:I Revised as per Rev I 05-12-07 JLM

Est Rev:J reformat 06.04.04 EC

Est Rev:K 07-03-20 As per DSI9361 JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-013 CHG004 CHG005 07-03-29

2.0

31543A

206B BASKET LID - UNDER REVIEW



Comment: Sub-Component 206B BASKET LID

D2330-043 B 31543 A

ml 07/08/15

3.0

31543B

206B BASKET BASE - UNDER REVIEW



Comment: Sub-Component 206B BASKET BASE

D2330-041 B 31543 B

ml 07/08/15

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 032572

07/08/15 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/03/2007 2:38:55 PM  
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Drawing Name: D206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER 030543

7.0

D2530

Handle Weldment



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment 031787

8.0

D2535

Spring



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 031486

9.0

D2537

Bushing



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing 032574

10.0

D2931

Bumper



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper 021139

11.0

MS20600AD4W3

Cherry Rivets



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet 1104715

*CP* 07/08/150

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M102140

13.0	AN424A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M101938

14.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M104093

15.0	D27283	Dart Logo label large
------	--------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Dart Logo label large

Batch: B22553

16.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M102959

17.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M104016

29/03/08/150

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Drawing Name: 206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

h Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer M104215

19.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104156

20.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M103344

21.0	AN960JD8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M104537

22.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104936

*CP 07/08/15 @*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

~~1102552~~ 1102552

24.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2258-170 Placard

~~1102552~~ B16266

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

~~1104118~~ 1104118

26.0

D33963

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch:

~~032784~~ 032784

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/15	26	These Spacer D3396-3 Should go in Picking list. Permanent Change.		<i>[Signature]</i> 07/08/15			<i>[Signature]</i> 07/08/16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

30.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041 Braket

B31485

31.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

B30543

32.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B32551

33.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671

34.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B27554

B07/08/160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526

Bushing

B23139-

36.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748

Clevis

B27560-

37.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1

Strut

B23423-

38.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3

Strut

B23424-

39.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2814

Strut

B23425-

40.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 AN4-12A

Description Batch

Bolt

M104547-

EP 07/08/16 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

M7188

42.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M100857

43.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M104016

44.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

M11695

45.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

19 AN960JD416 Washer

M104215

46.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M104156

CP 07/08/100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

1103344-

48.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

1102552-

49.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

1104118-

50.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

113355-

51.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

119599-

52.0

AN3204

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

117195-

1107/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31543

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M16895

CP

07/08/16

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SW

07/08/16

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location:

PPP Rev: H

CP 07/08/16

SP

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/21

Job Completion



07-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

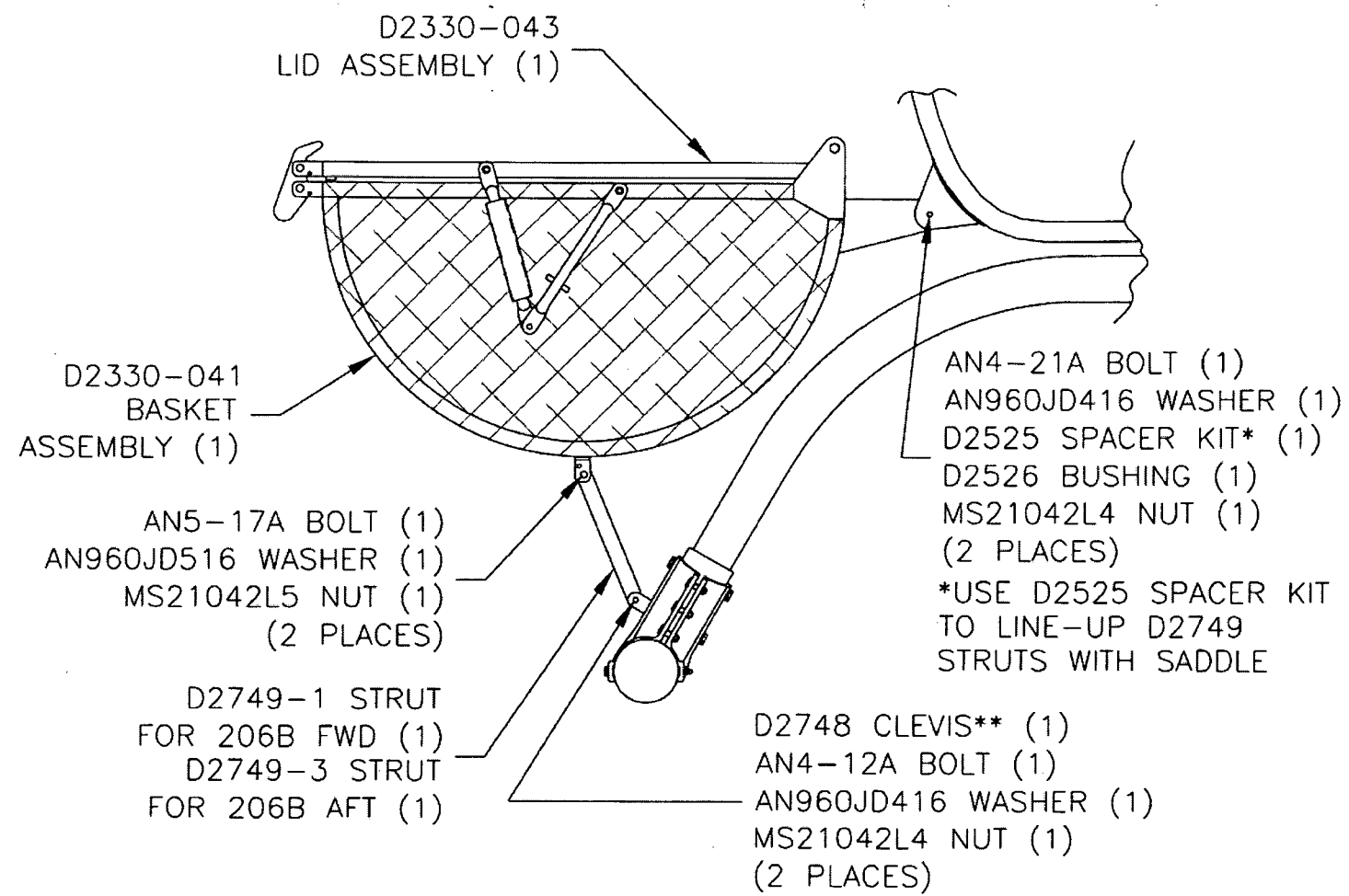
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	KE	DRAWN BY	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D206-540
DATE	05.11.10	TITLE	UTILITY BASKET INSTALLATION		
				REV. 1	SHEET 6 OF 8
				SCALE	NTS



\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

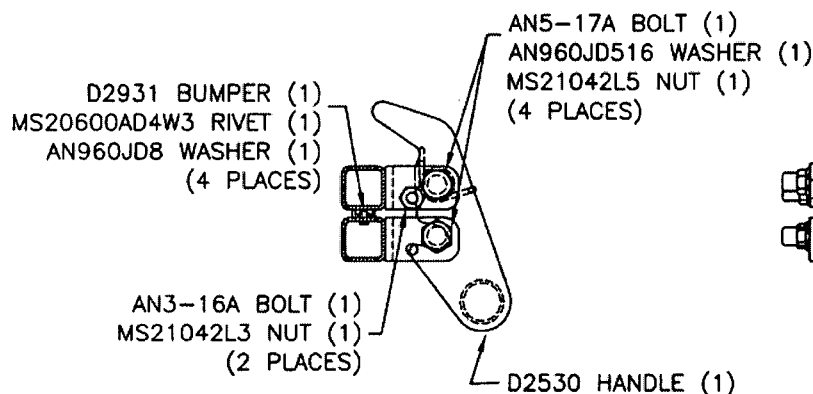
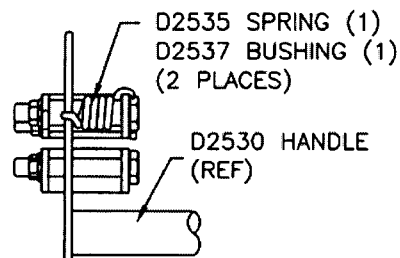
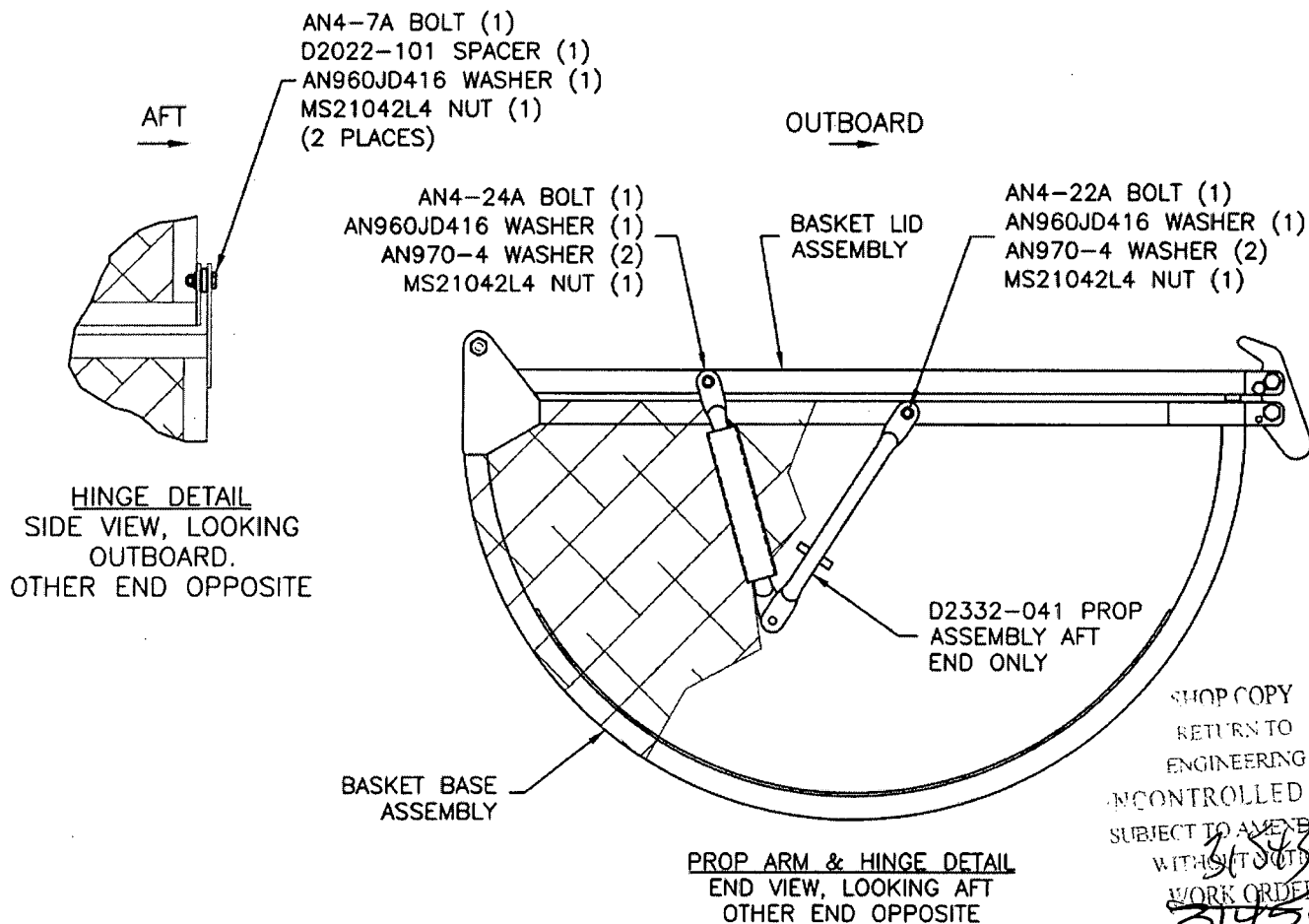
SECTION A-A AND B-B  
D206-540-013 (206 A/B) ONLY

NO  
34452  
WORK ORDER  
WITHIN 30 DAYS  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
SHOP COPY  
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**DART**

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-540	REV. 1 SHEET 8 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

LATCH DETAILSPRING DETAIL

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITH SITE  
WORK ORDER  
31456

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DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9361	REV. A SHEET 1 OF 1
DATE 07.03.15		TITLE UTILITY BASKET SPACER	SCALE NTS
A	07.03.15	NEW ISSUE	

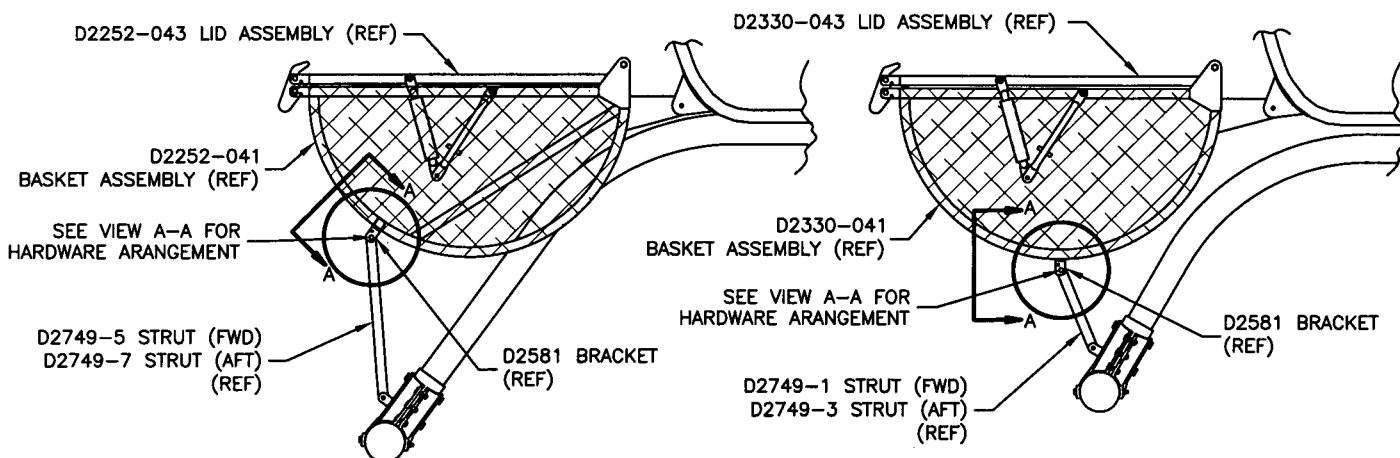
## DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I  
REF. CANADIAN STC: SH94-5  
REF. FAA STC: SR00386NY

The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

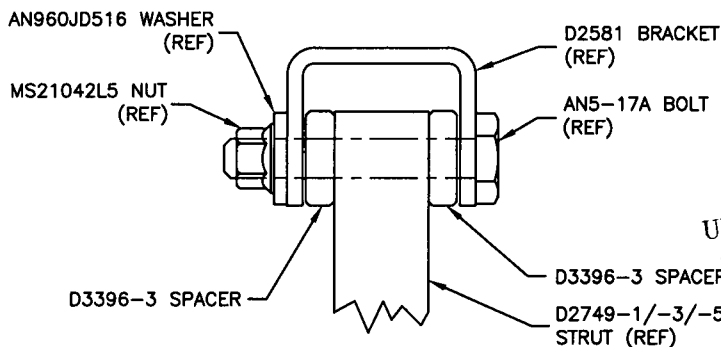
Qty - 011	Qty - 013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
4	4	D3396-3	SPACER

Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011  
INSTALLATION**

**FIGURE 2 - D206-540-013  
INSTALLATION**



**VIEW A-A - HARDWARE  
ARRANGEMENT (TYP)**

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WORK ORDER  
NO. 31456

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

*[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.03.15  
CERT. NO.: SH94-5  
ISSUE NO.: 4

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14

Date: Thursday, 3/29/2007 2:45:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B UTILITY BASKET
Job Number	: 31543		
Estimate Number	: 11282		
P.O. Number	:	Part Number	: D206540013
This Issue	: 3/29/2007 S.O. No. :	Drawing Number	: D206-540 REV I
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/29/2007 Type : LARGE FAB ASSY	Drawing Revision	: I
Previous Run	: 31455	Material	:
Written By	: <u>W</u>	Due Date	: 4/6/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	Est Rev: I Revised as per Rev I 05-12-07 JLM Est Rev: J reformat 06.04.04 EC Est Rev: K 07-03-20 As per DSI9361 JLM		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL

First Issue



Comment:

DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD206-540-013 CHG004-005

07.03.28

2.0

31543A

206B BASKET LID - UNDER REVIEW



Comment:

Sub-Component 206B BASKET LID

D2330-043 B

3.0

31543B

206B BASKET BASE - UNDER REVIEW



Comment:

Sub-Component 206B BASKET BASE

D2330-041 B

REFERENCE ONLY

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment:

PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0

D2332041

Lid Prop Assembly 6.69"



Comment:

Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

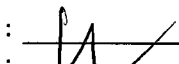
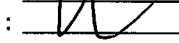
1 D2332-041 Prop Ass'y





Date: Thursday, 29/03/2007 2:39:46 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206B BASKET LID - UNDER REVIEW
<b>Job Number</b> : 31543A	
<b>Estimate Number</b> : 11280	
<b>P.O. Number</b> :	
<b>This Issue</b> : 29/03/2007 <b>S.O. No.</b> :	<b>Part Number</b> : D2330043
<b>Prsht Rev.</b> : NC	<b>Drawing Number</b> : D2330 UNDER REVIEW
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Project Number</b> : N/A
<b>Previous Run</b> : 31455A	<b>Drawing Revision</b> : E
	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 06/04/2007
<b>Checked &amp; Approved By</b> : 	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K	

AS DISCUSSED WITH BILL B,  
 PROCEED (SEE NOTE ON  
 # 31456 )/N),  
 07.03.27

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



✓ **Comment:** Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M104980

Pl 07.08.13

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

Pl 07.08.13

3.0	D22321	Hinge
-----	--------	-------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2232-1 HINGE

Batch

B29535

Pl 07.08.13

4.0	D2329	Label Plate
-----	-------	-------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2329 Label Plate

Batch

B29936

Pl 07.08.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/03/2007 2:39:46 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 31543A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch  
1 D2327-1 Bushing ~~B2055~~ B31693

Ppl 07.08.13

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch  
2 D2581 Mounting Chanel B32066

Ppl 07.08.13

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

✓ Qty Part Number Description Batch  
18 sf M304EX0.75-16F Expanded Metal M104711

Ppl 07.08.13

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Debur as required

✓ A/R SS ROD Batch: M105138

Ppl 07.08.13

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ppl 07.08.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 29/03/2007 2:39:46 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 31543A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



*M 105068*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/M 07-08-14*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*mul 07/08/15*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*mul 07/08/15*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07-08-16*

Job Completion



*u 07-08-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

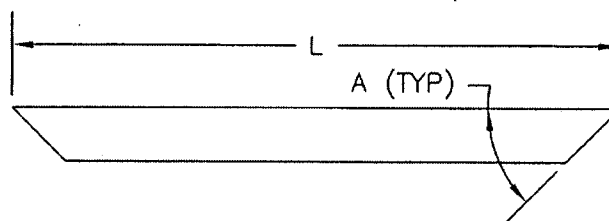
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

**NOTES:**

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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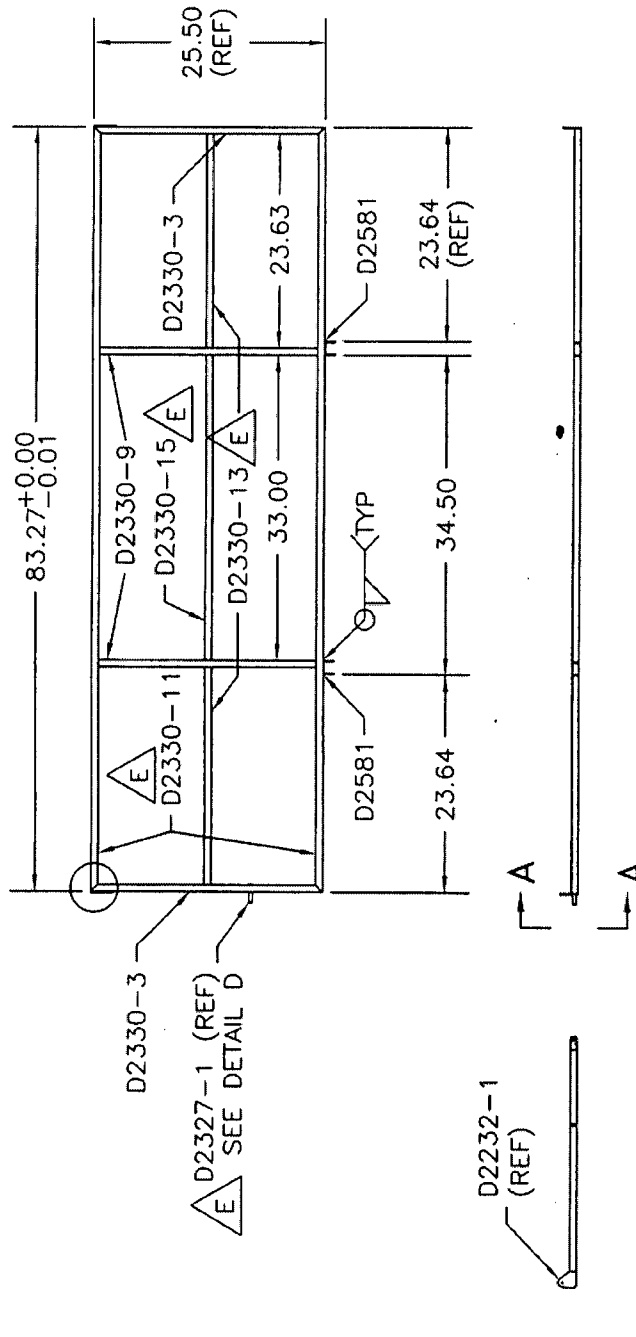
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



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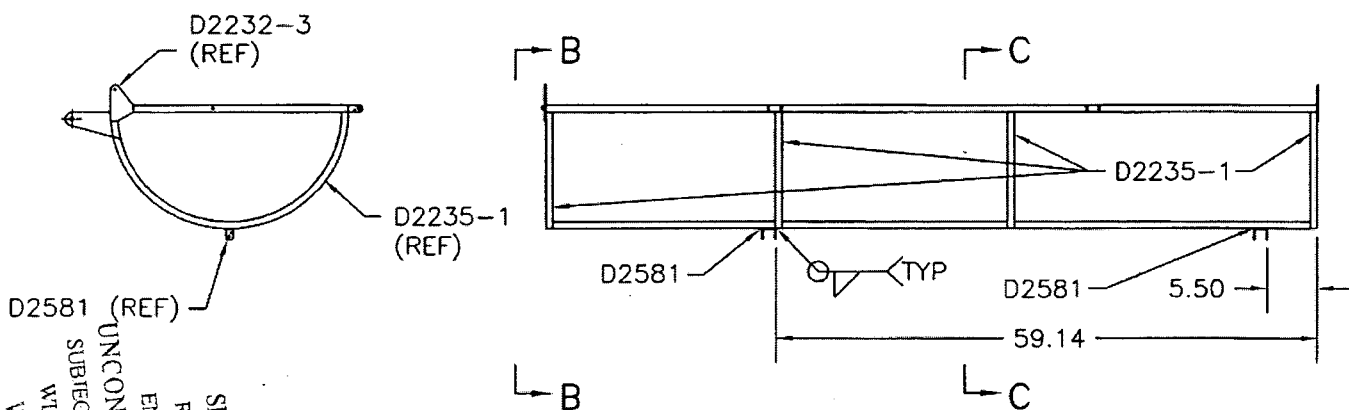


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DATE	05.11.10			TITLE	BASKET ASSEMBLY (206B)
				REV. E	SHEET 3 OF 5
				SCALE	NTS



D2330-041 BASKET FRAME

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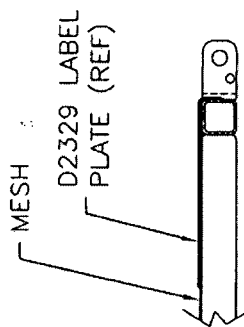
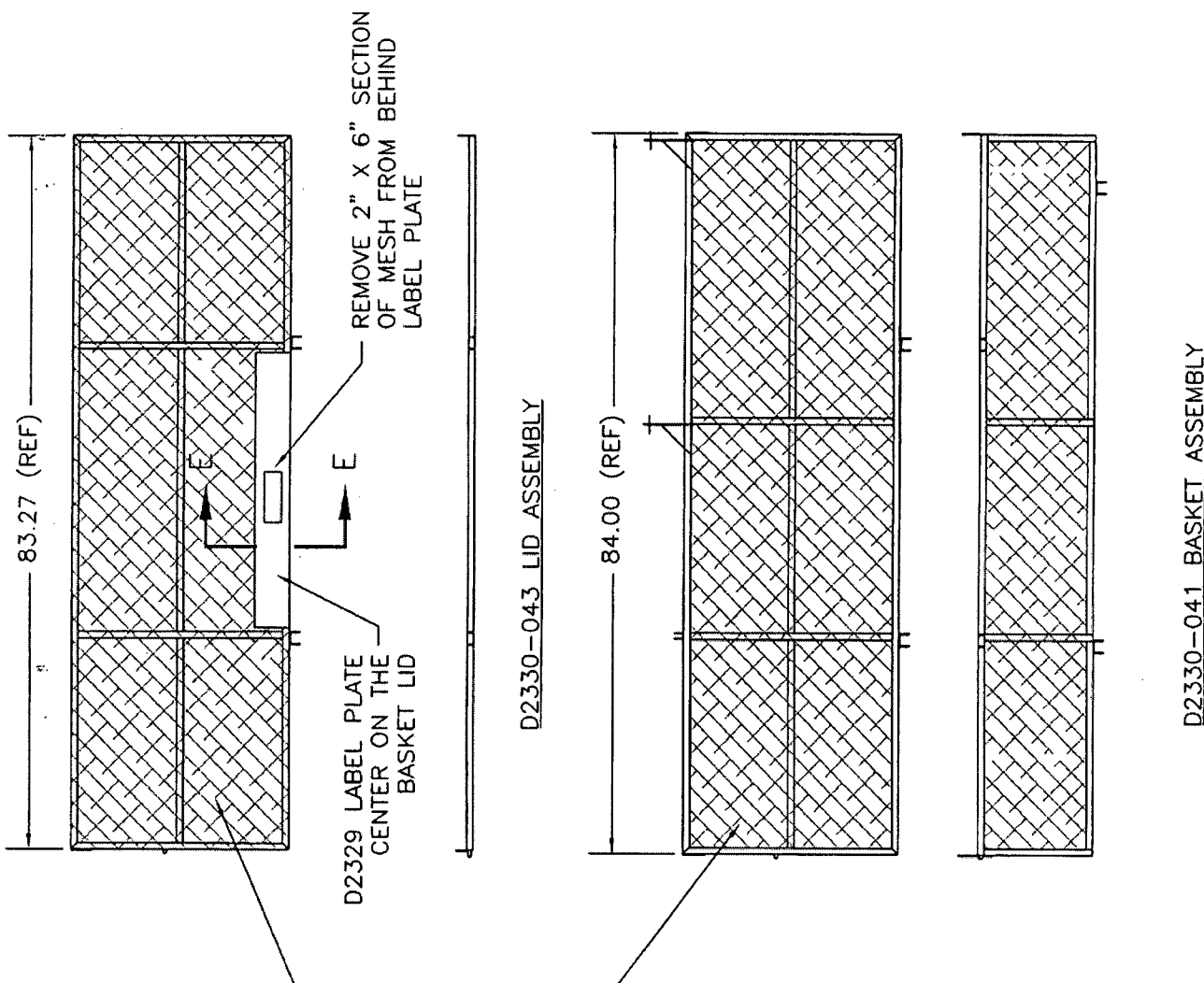
WELD ALL JOINTS  
AS SHOWN

The diagram shows a horizontal pipe with a T-junction. A weld symbol is shown on the pipe, consisting of a circle with a square inside, divided into four quadrants. A circular detail view is shown to the right of the weld symbol, showing a cross-section of the pipe and the weld. The weld is a fillet weld. The pipe is labeled 'TYP' at both ends.

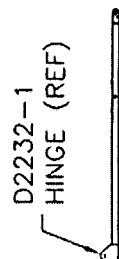
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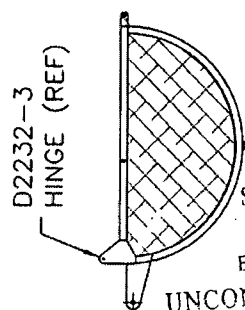
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



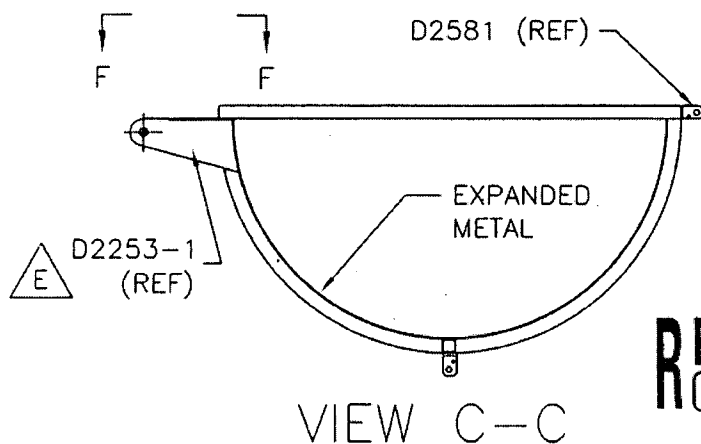
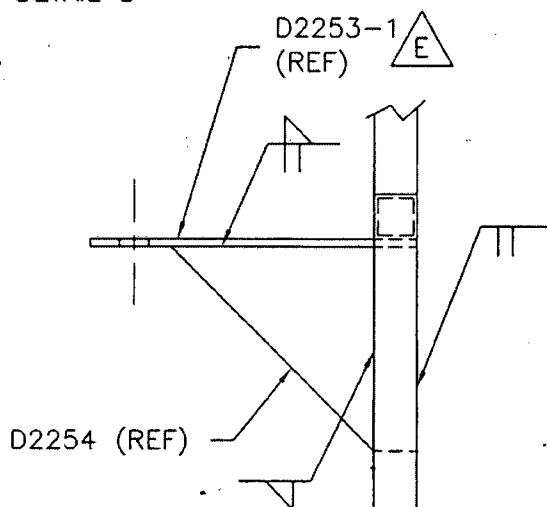
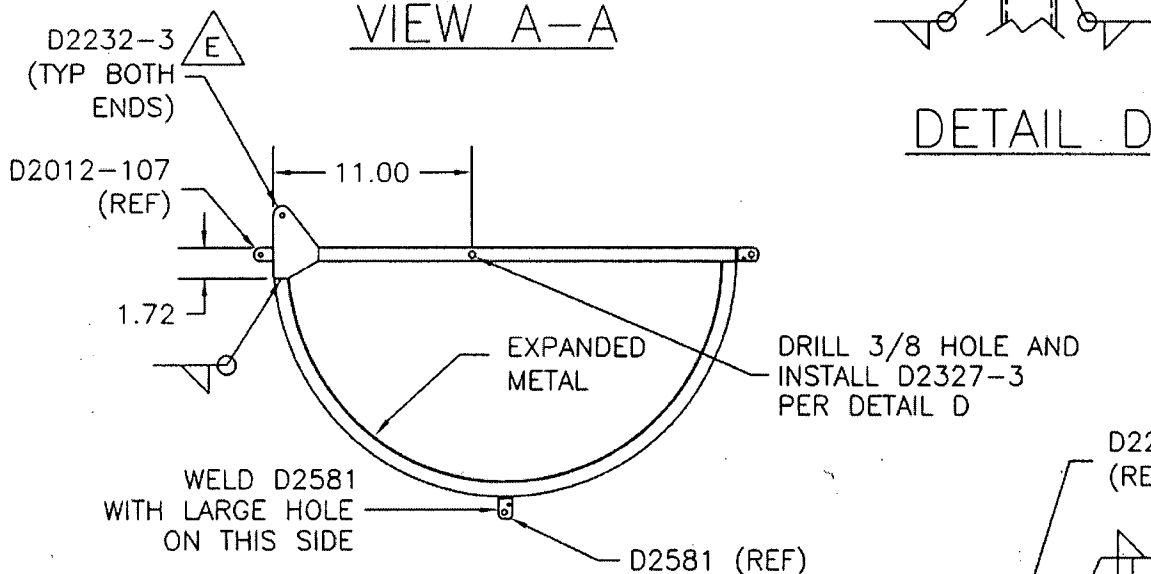
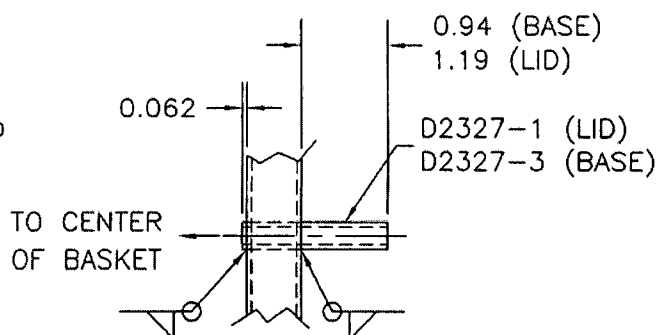
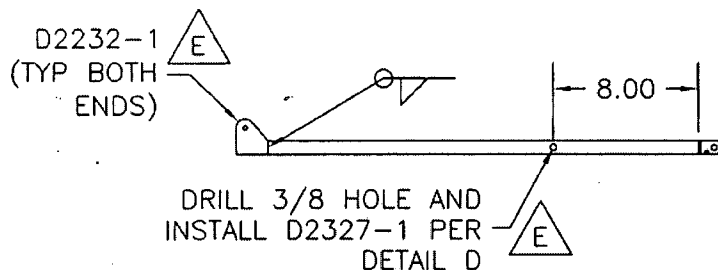
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CHECKED 	APPROVED 	DRAWING NO. D2330	REV. E SHEET 5 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



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Date: Thursday, 29/03/2007 2:40:04 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206B BASKET BASE - UNDER REVIEW
<b>Job Number</b> :	31543B	<b>Part Number</b> :	D2330041
<b>Estimate Number</b> :	11276	<b>Drawing Number</b> :	D2330 UNDER REVIEW
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	29/03/2007	<b>Drawing Revision</b> :	E
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	1/1	<b>Due Date</b> :	06/04/2007
<b>Previous Run</b> :	31455B	<b>Type</b> :	LARGE FAB ASSY
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K		

As discussed with  
POLL. B., PROCEED.  
(SEE NOTE ON  
#31456 J/N),  
07.03.27

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop
<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: ✓ Qty Part# Description Batch 4 D3166-1 Hoop B32067		
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
✓ <b>Comment:</b> Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M104980		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Cut 4 D2235-1 From D3166-1  2- Cut D2330-1-3-5-7-9 as per Dwg D2330  3-Drill hole in D2330-3 as per Dwg D2330  4-Deburr		
4.0	D22531	Lug
✓ <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Gusset Batch: B27553		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/03/2007 2:40:04 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 31543B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis

332551

PL 07-08-13

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

330876

PL 07-08-13

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chancel

332066

PL 07 08 13

8.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug

3323421

PL 07/08/13

9.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE

331784

PL 07 08 13

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total: 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

M104711

PL 07 08 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 29/03/2007 2:40:04 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 31543B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD

Batch: m105138

*CP 07-08-13*

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/08/13*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/08/13*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 105088*

*BL/M 07-08-15*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m 07/08/15*

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*m 07/08/15*

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/08/15*

Job Completion



*u 07-08-16*

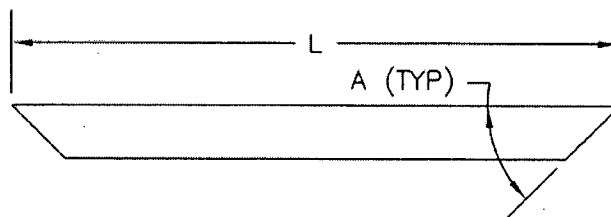
**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

## NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



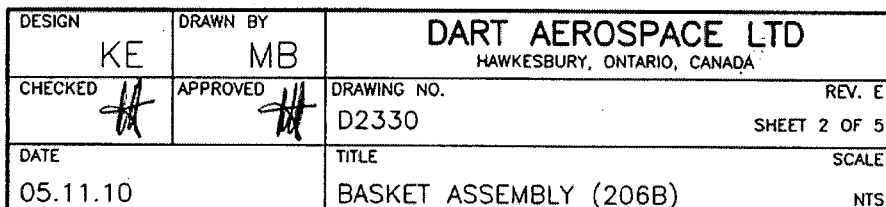
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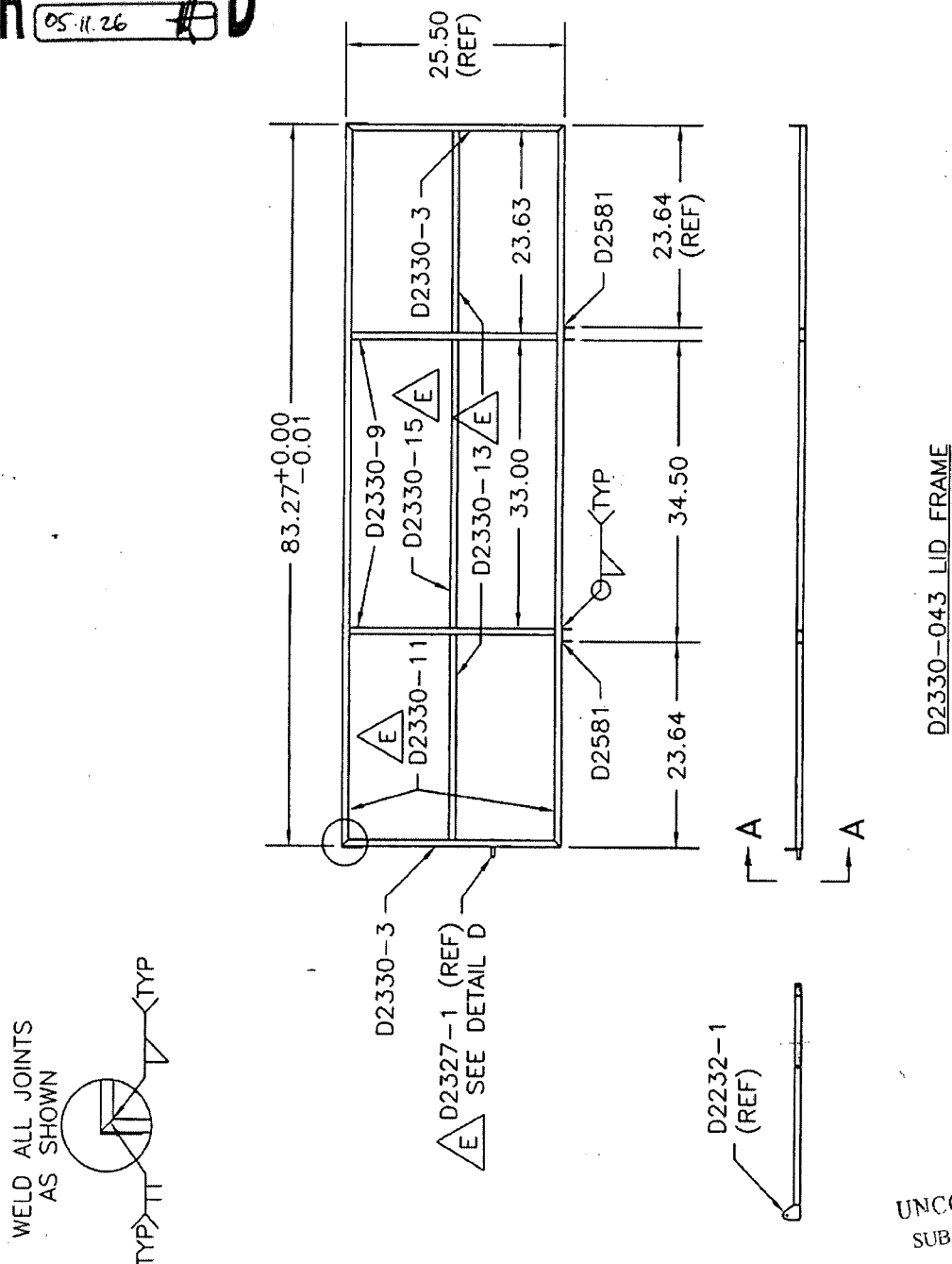
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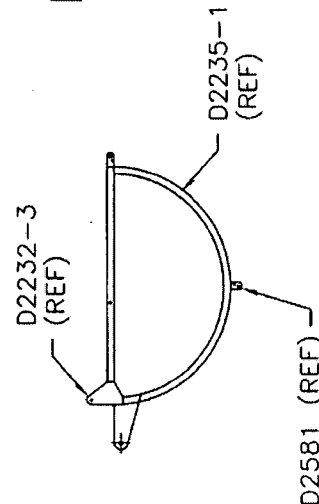
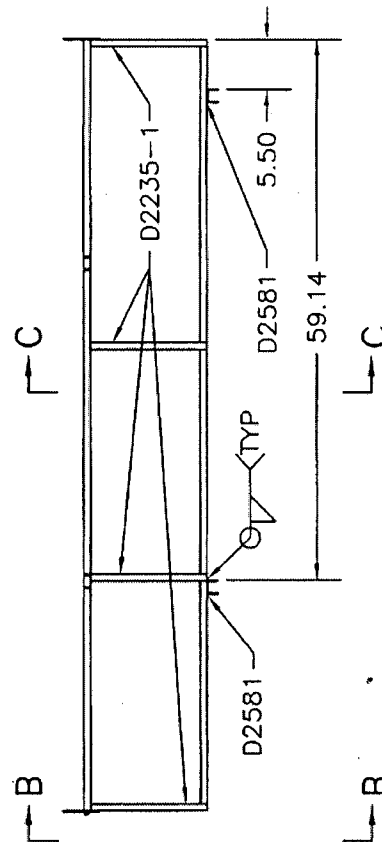
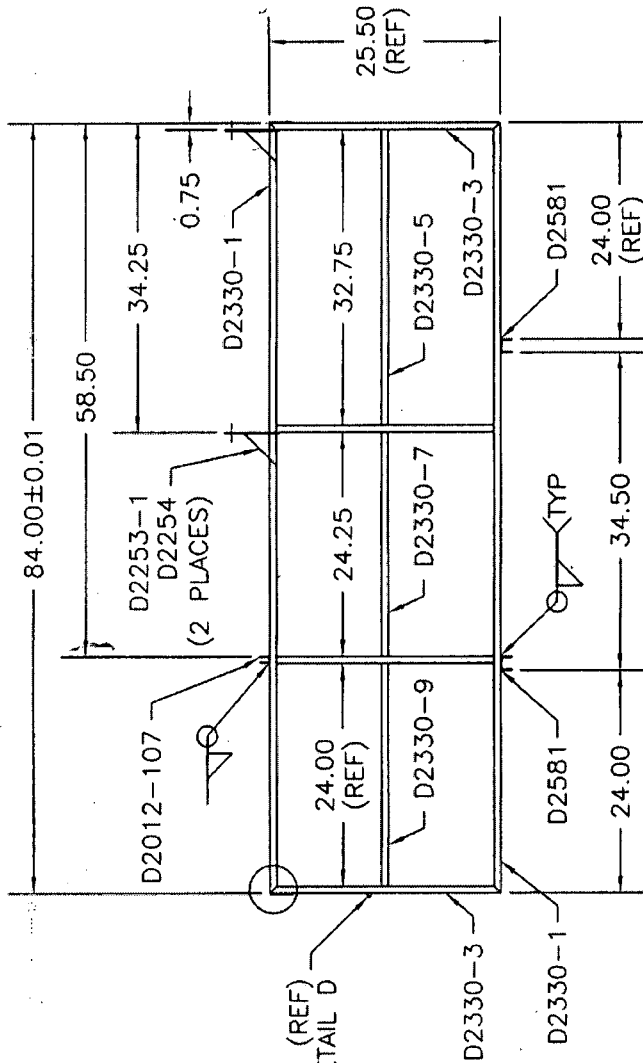
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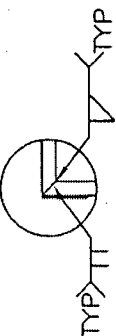


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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



D2330-041 BASKET FRAME

WELD ALL JOINTS  
AS SHOWN



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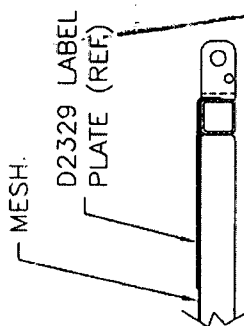
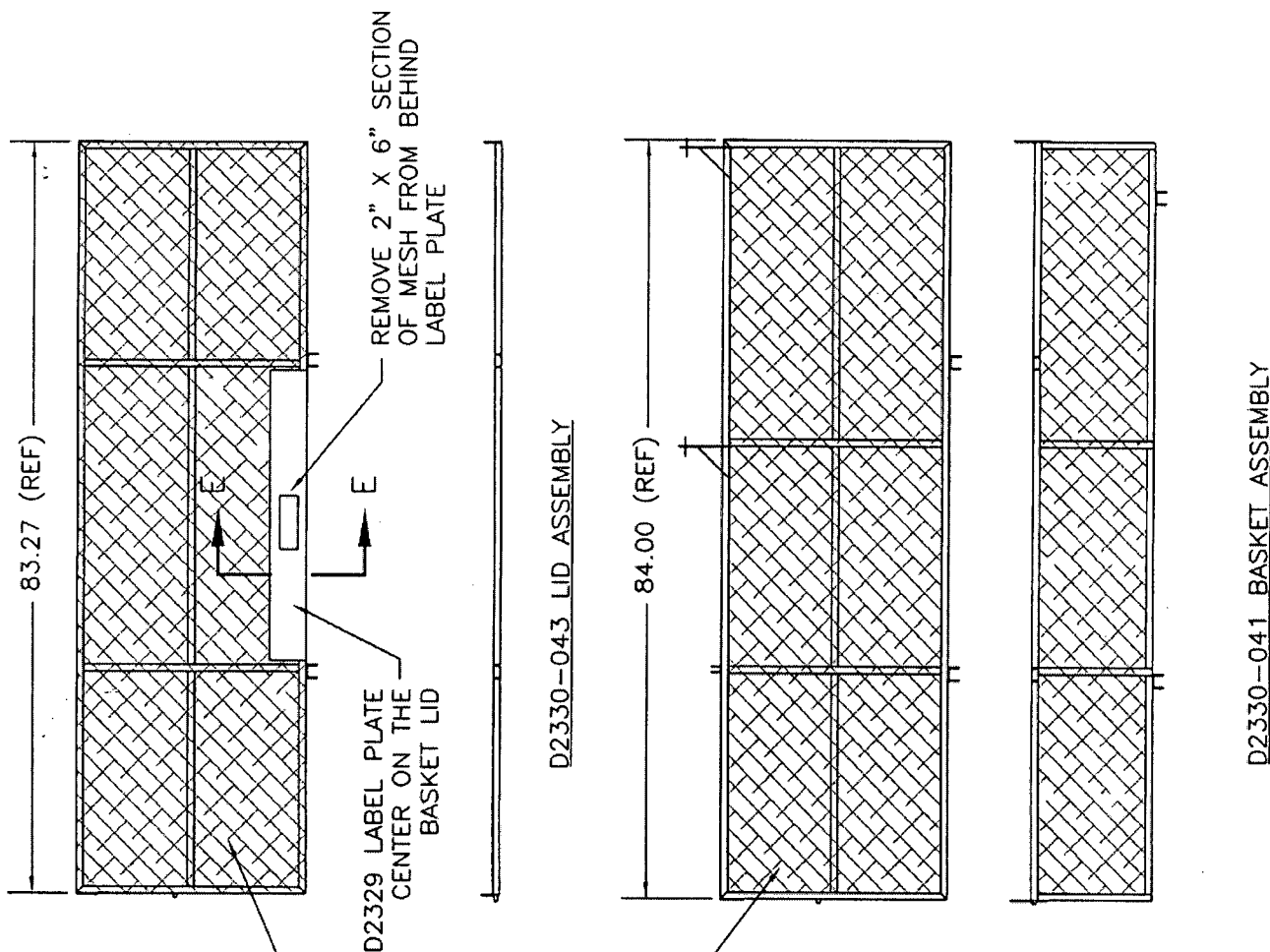
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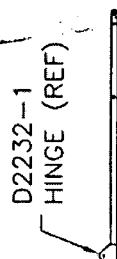
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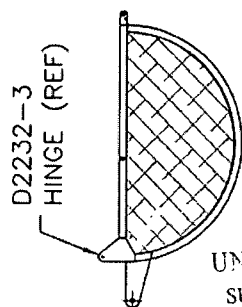
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS



SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



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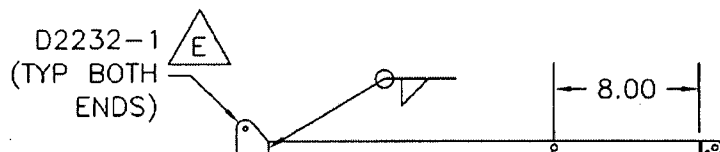
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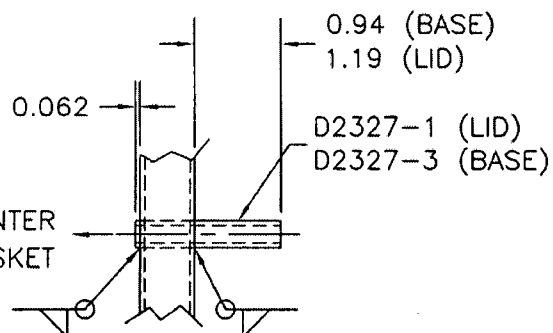


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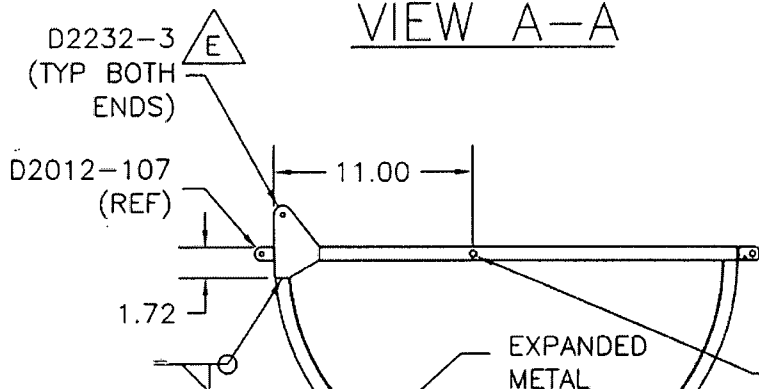


DRILL 3/8 HOLE AND  
INSTALL D2327-1 PER  
DETAIL D

VIEW A-A



DETAIL D

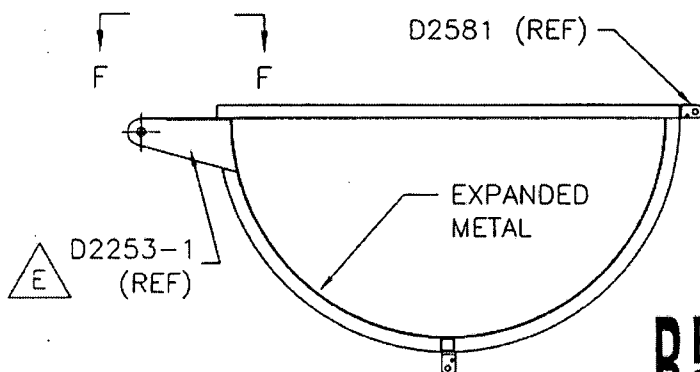
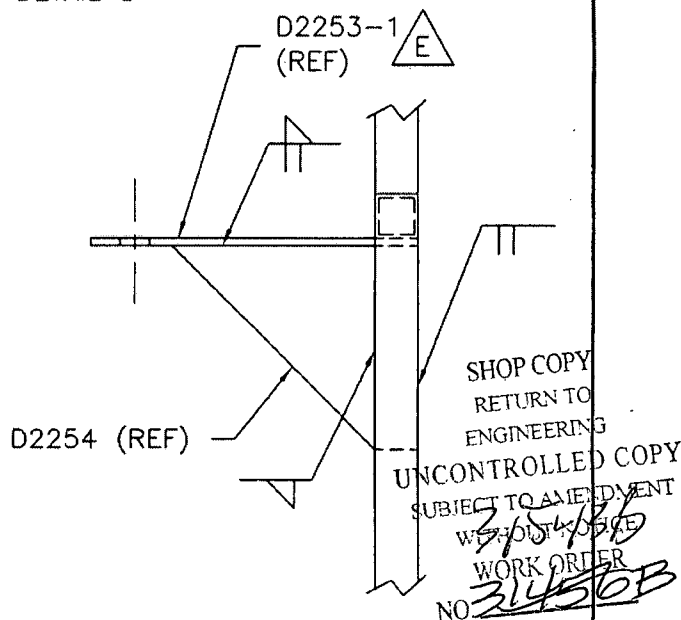


DRILL 3/8 HOLE AND  
INSTALL D2327-3  
PER DETAIL D

WELD D2581  
WITH LARGE HOLE  
ON THIS SIDE

D2581 (REF)

VIEW B-B



VIEW C-C

VIEW F-F

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